

Date: Monday, 5/15/2006 11:16:24 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 27126
Estimate Number : 10183
P.O. Number : N/A
This Issue : 5/15/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : 5/15/2006 Type : PURCHASED PARTS
Previous Run : 26026
Written By : See comment below
Checked & Approved By : 06.05.15
Comment : Est: C 03.06.08 Reformat; Remove Tumble KJ/RF

Drawing Name : BRACKET, GAS SPRING STUD
Part Number : D2154
Drawing Number : D2154 REV. C
Project Number : N/A
Drawing Revision : C
Material : N/A
Due Date : 6/4/2006
Qty: 50 Um: 20 Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 1263
Email or Ship DXF file to vendor
Laser Cut flat pattern per Dwg D2154
Material release note is required

C 206105116 (50)

2.0 D2154F Bracket, Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
BRACKET, GAS SPRING STUD

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached

116105116 (54)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06.05.29 54

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary

M.F. 06.05.30 (59)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 06/06/12

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 11:16:24 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET, GAS SPRING STUD

Job Number: 27126

Part Number: D2154

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2154

Rev: C

SP 06/06/01 54

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EN 06/06/02 (54)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

FC 06 06 02 (54)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/06/05 (21)

EN 06/06/05

(29)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5126

06/06/09 50 MP

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DA 06/06/09

(50)

Job Completion



06-06-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
		split - 21 to be repaired				U dodo-05	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

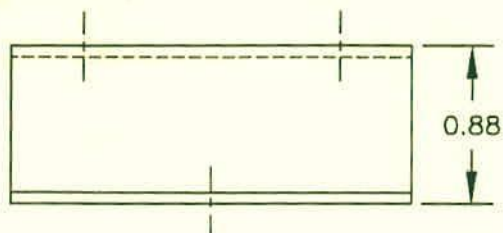
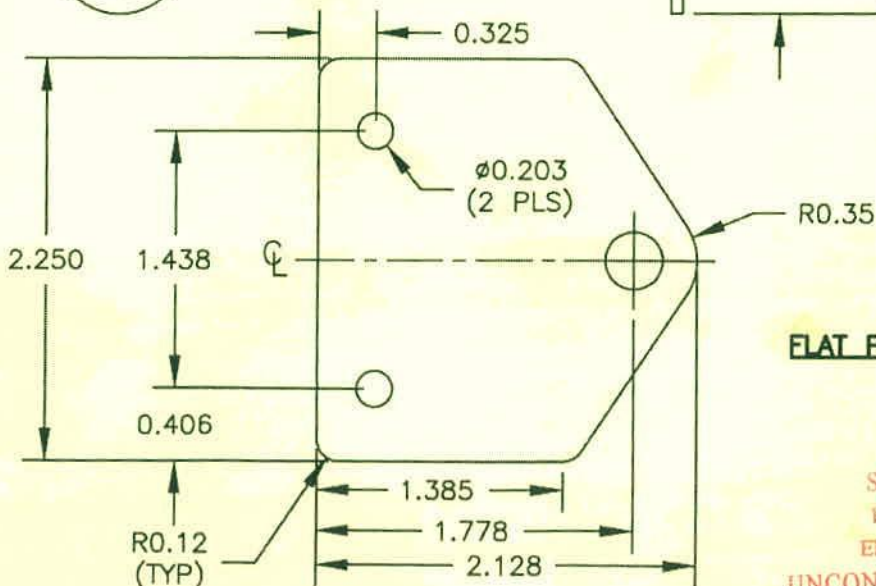
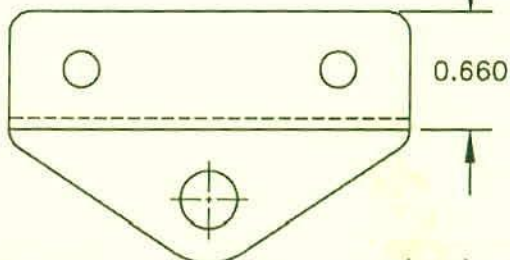
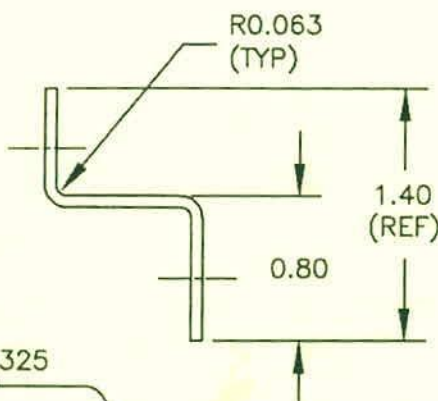
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN GH	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2154	REV. C SHEET 1 OF 1
DATE 04.10.12	TITLE BRACKET, STUD		SCALE 1:1
A	92.07.28	NEW ISSUE	
B	98.09.15	UPDATE FLAT PATTERN; ADD P/COAT	
C	04.10.12	0.88 WAS 0.875; 2.128 WAS 2.068	

RELEASED04.10.15 *[Signature]***BEND DETAIL****FLAT PATTERN****D2154 NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 0.063 THICK (M304S16GA)
- 2) FINISH: POWDER COAT WHITE (REF: 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH PART NUMBER AND BATCH NUMBER USING A FINE POINT PERMANENT INK MARKER.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27126

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CAMBRIDGE STEEL MILL
160 ORION PLACE
CAMBRIDGE ON N1T 1R9 CAN
(519) 740-2488

Chemical and Physical Test Report

MADE IN CANADA

N-037186

SHIP TO VEDDER TRANSPORT C/O WILKINSON STEEL AND METALS 588 RIVERSIDE ROAD ABBOTSFORD, BC	INVOICE TO WILKINSON STEEL & METALS VAN PREMETALCO INC 888 SOUTHEAST MARINE DR. VANCOUVER, BC V5X 2V3	SHIP DATE 01/12/06 CUST. ACCOUNT NO 69073699
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SHAPE + SIZE			GRADE		SPECIFICATION													SALES ORDER		CUST P.O. NUMBER																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																				
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Mechanical Test: Yield 50258 PSI, 346.52 MPa Tensile: 74435 PSI, 513.21 MPa %E: 27.0/8in, 27.0/200MM Red R 26.7 : 1
Mechanical Test: Yield 49665 PSI, 342.43 MPa Tensile: 74737 PSI, 515.29 MPa %E: 27.0/8in, 27.0/200MM Red R 26.7 : 1

Mechanical Test:		Yield 49665 PSI, 342.43 MPa		Tensile 74737 PSI, 519.29 MPa		SECT 27.0000, 27.00200000		50000 200000		SALES ORDER		CUST P.O. NUMBER																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																				
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Mechanical Test: Yield 48109 PSI, 331.7 MPa Tensile: 70847 PSI, 488.47 MPa %E: 28.5/8in, 28.5/200MM Red R 26.7 : 1
Mechanical Test: Yield 48088 PSI, 331.56 MPa Tensile: 71075 PSI, 490.04 MPa %E: 28.0/8in, 28.0/200MM Red R 26.7 : 1

Mechanical Test		Yield 48088 PSI, 331.56 MPa		Tensile 71075 PSI, 490.94 MPa		Elong 20.00%, 20.0000mm		Reduc 3.00%, 3.0000mm		SALES ORDER		CUST P.O. NUMBER																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																						
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Mechanical Test: Yield 50567 PSI, 348.65 MPa Tensile: 73436 PSI, 506.32 MPa %E: 27.0/8in, 27.0/200MM Red R 26.7 : 1
Mechanical Test: Yield 50554 PSI, 348.56 MPa Tensile: 73611 PSI, 507.53 MPa %E: 27.0/8in, 27.0/200MM Red R 26.7 : 1

This material, including the billets, was produced and manufactured in Canada.

A.J. Turner

Quality Assurance Manager

Mill Group

THE ABOVE FIGURES ARE CERTIFIED EXTRACTS FROM THE ORIGINAL CHEMICAL AND PHYSICAL TEST RECORDS
AS CONTAINED IN THE PERMANENT RECORDS OF COMPANY

Mgr. Metallurgy Svcs.

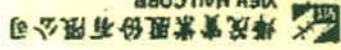
CAMBRIDGE STEEL MILL

JAN-10-2006 16:59

CLBERT METAL SALES

505 795 1322

P.03

VIEH MAU CORP.
PUSHMA29

COMMODITY : PRDAE COLD ROLLED STAINLESS STEEL SHEET

SPECIFICATION : AISI 304

CUSTOMER : CLBERT METAL SALES LIMITED

MILL TEST CERTIFICATE

1. 廠址: 臺灣桃園市桃園區中興路346號
245, SHUN AN RD. LI CHU HSIANG
KAOSHUN TAIWAN R.O.C
TEL: (07) 8812286 FAX: (07) 8812006
CERTIFICATE NO: P03MA29
DATE OF ISSUE: 11/20/2005

ORIGINAL

8731

SIZE	NO.	Weight (N.W.)	Heat No.	ID NO.	Physical Properties					Chemical Composition				
					YS	TS	EL	HB	HV	C	Si	Mn	P	S
					(N/mm ²)	(N/mm ²)	(%)	CL-50 data		x100	x100	x100	x1000	x1000

16GA / 48" X 96"	1	1.476	YU236038	4AS16193A-32	297	659	51	79	43	46	48	105	32	12
16GA / 48" X 96"	1	1.479	YU236038	4AS16193A-21	316	690	50	91	158	4.1	65	124	31	7
16GA / 48" X 96"	1	1.479	YU236038	4AS16193A-11	316	690	50	81	158	4.1	65	124	31	7
16GA / 48" X 96"	1	1.479	YU236038	4AS16193A-12	316	690	50	80	155	4.3	65	124	31	7
16GA / 48" X 120"	1	1.536	YU236038	4AS16193A-13	315	675	51	80	155	4.3	65	124	31	7
16GA / 48" X 120"	1	1.538	YU236038	4AS16193A-14	315	675	51	80	155	4.3	65	124	31	7
16GA / 48" X 120"	1	1.540	YU236038	4AS16193A-15	315	675	51	80	155	4.3	65	124	31	7
16GA / 48" X 120"	1	1.541	YU236038	4AS16193A-16	315	675	51	80	155	4.3	65	124	31	7
16GA / 48" X 120"	1	1.603	YU236038	4AS16193A-17	315	675	51	80	155	4.3	65	124	31	7
16GA / 48" X 120"	1	1.633	YU236038	4AS16193A-18	316	690	50	81	158	4.1	65	124	31	7
16GA / 48" X 144"	1	1.338	YU236038	4AS16193A-19	316	690	50	79	149	4.3	48	105	32	12
120A / 48" X COIL	1	2.293	YU139969	4S18207A-11	310	626	52	83	163	4.5	46	127	31	7

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE

NO MANUFACTURING CONTINUATION
Heat not good for all test NO.

VIEH MAU CORP.

Manager of Quality Assurance Division
Lin Kun Shing

06.05.25

THE
LIBRARY
OF THE
MUSEUM OF
COMPARATIVE ZOOLOGY
AT
HARVARD UNIVERSITY
CAMBRIDGE, MASS.
1880